

Date: Wednesday, 5/16/2007 1:28:17 PM  
 User: Kim Johnston

## Process Sheet

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	LUG EXTRUSION				
Job Number	32388	Part Number	D27317				
Estimate Number	10326	Drawing Number	D2731 REV B				
P.O. Number	N/A	Project Number	N/A				
This Issue	5/16/2007	S.O. No.	N/A				
Prsht Rev.	NC	Type	MACHINED PARTS				
First Issue	N/A	Material	N/A				
Previous Run	32387	Due Date	6/6/2007				
Written By						Qty: 64	Um: Each
Checked & Approved By	<i>John 05.16</i>						
Comment	Est D 00.06.19 Added inspect level 8, removed P/O powder coating EC						

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:		
1.0	D2423	Lug Extrusion		
Comment: Qty.: 0.0717 f(s)/Unit Total: 4.5898 f(s) Lug Extrusion D2423 Batch: <i>30062</i> <i>C20705122</i>				
2.0	BAND SAW	BAND SAW		
Comment: BAND SAW Cut D2423 extrusion to .82" Batch _____				
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1		
Comment: HAAS CNC VERTICAL MACHINING #1 <i>PG issue P/O 3812</i> 1-Machine as per folio D2731-7. 2-Check for crack while loading into the machine. 3-Tumble 4-Deburr any rough edges after tumbling <i>Machine pending D2731 Rev. B</i>				
4.0	QC2 <i>RC</i>	INSPECT PARTS AS THEY COME OFF MACHINE		
Comment: INSPECT PARTS AS THEY COME OFF MACHINE <i>received + inspect for trans. damage</i> <i>John 06-06</i>				
5.0	QC5	SECOND CHECK		
Comment: SECOND CHECK <i>inspect. level 8</i> <i>John 06-06</i> <i>64 counted</i>				

## WORK ORDER CHANGES

W/O:		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
DATE	STEP						

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 07/06  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Section B	Sign & Date			

NOTE: Date &amp; initial all entries

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG EXTRUSION

Job Number: 32388

Part Number: D27317

Job Number:



Seq. #: Machine Or Operation:

Description:

6.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

W

07-06-07

couated  
64

7.0 SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING

-PRIME

-PAINT DELFLEET BLUE (PER QSI005)

-CLEAR DELFLEET

MX

8.0 QC14

INSPECT SPRAY PAINT



Comment: INSPECT SPRAY PAINT

9.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

Stock un painted

st 403

7/7/07 (64)

64

10.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

7/7/07 (64)

Job Completion



W 7/7/07 (64)

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	32388
Description: Lug	Part Number:	D2731-7
Inspection Dwg: D2731	Rev: B	Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

## X First Article      Prototype

W W W  
J metec

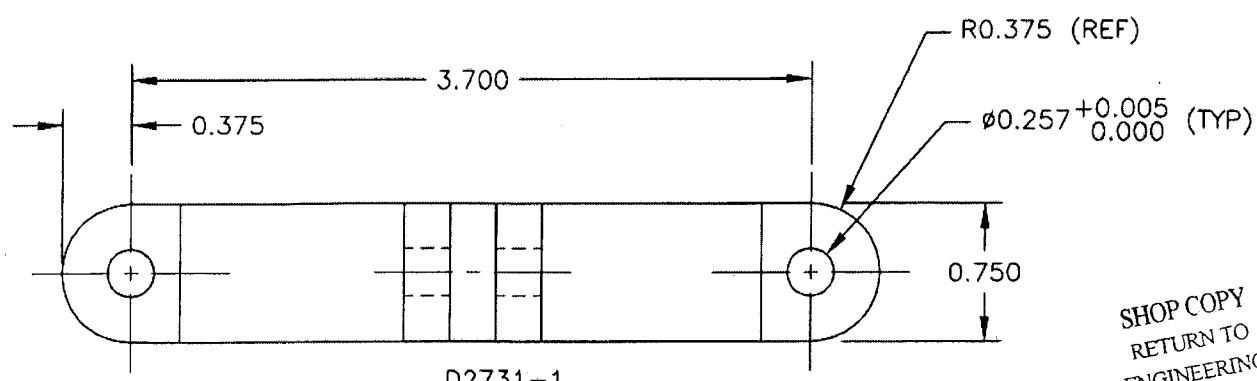
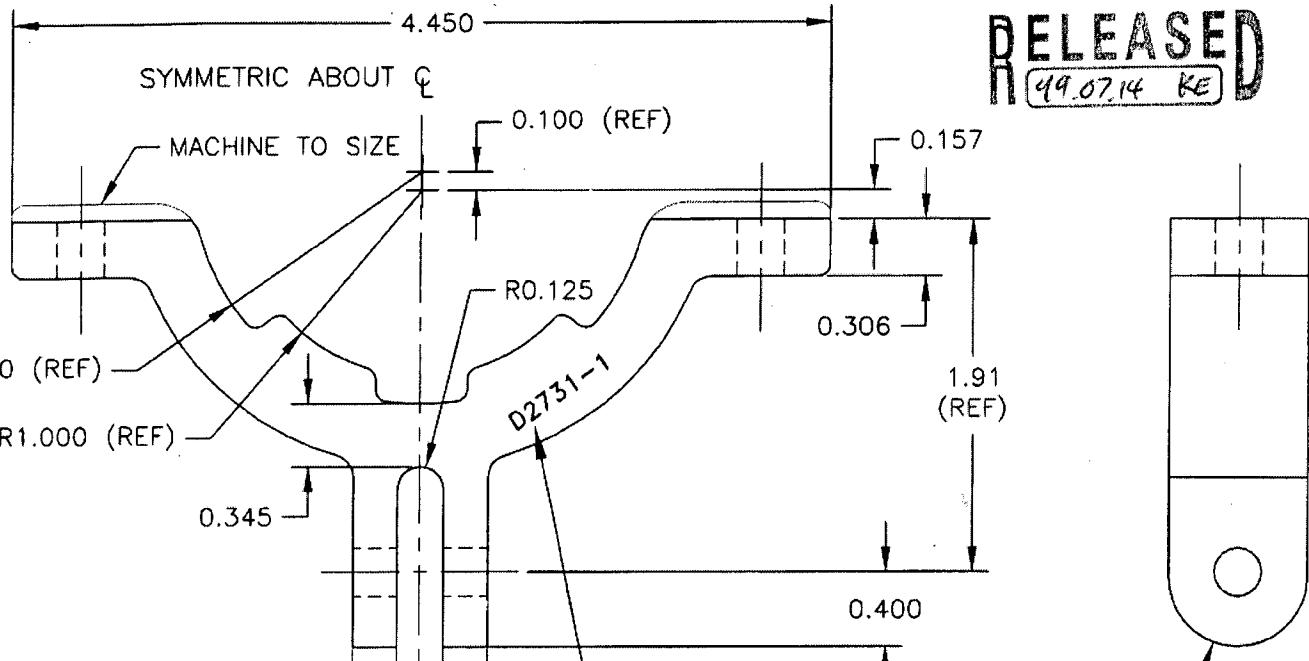
<b>Measured by:</b>		<b>Audited by:</b>		<b>Prototype Approval:</b>	N/A
<b>Date:</b>		<b>Date:</b>		<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	04.04.22	New Issue	KJ/RF	
B	04.05.06	Dimension change	KJ/RF	



DATA COPY  
DRAFT

DESIGN <i>KE</i>	DRAWN BY <i>RF</i>	DART AEROSPACE USA, INC. FAIRCHILD INTERNATIONAL AIRPORT, WA
CHECKED <i>KE</i>	APPROVED <i>JX</i>	DRAWING NO. D2731
DATE 99.07.06		TITLE MOUNTING LUG
		SCALE 1:1
A	98.05.13	NEW ISSUE
B	99.07.06	REVISED DIMENSIONS



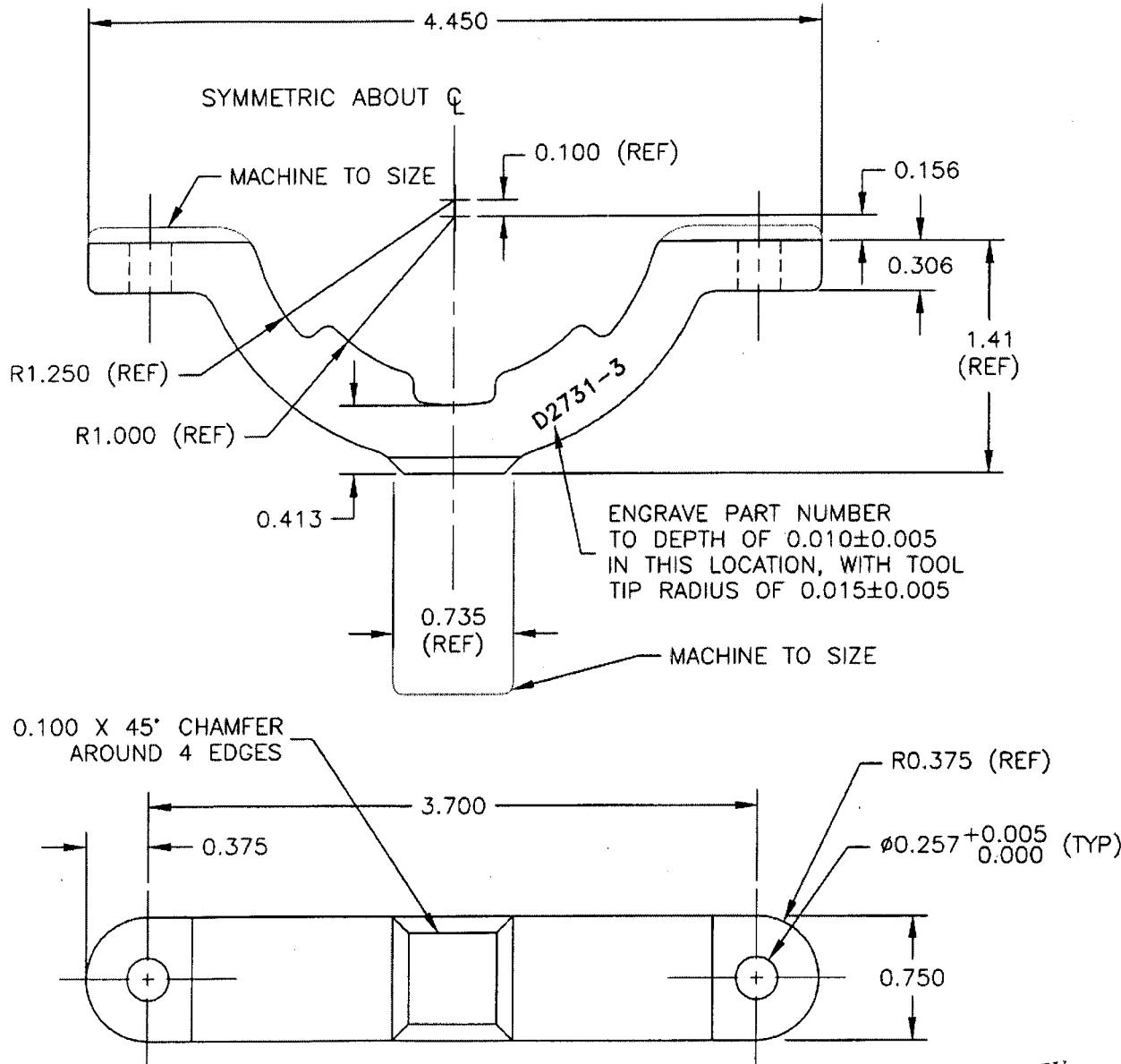
MAKE FROM EXTRUSION D2423  
BREAK ALL EDGES 0.000-0.015  
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. *32388*



DESIGN KE	DRAWN BY RF	DART AEROSPACE USA, INC. FAIRCHILD INTERNATIONAL AIRPORT, WA
CHECKED KE	APPROVED JK	DRAWING NO. D2731
DATE 99.07.06		REV. B SHEET 2 OF 4 SCALE 1:1

RELEASED  
19.07.14 KE



MAKE FROM EXTRUSION D2423  
BREAK ALL EDGES 0.000-0.015  
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

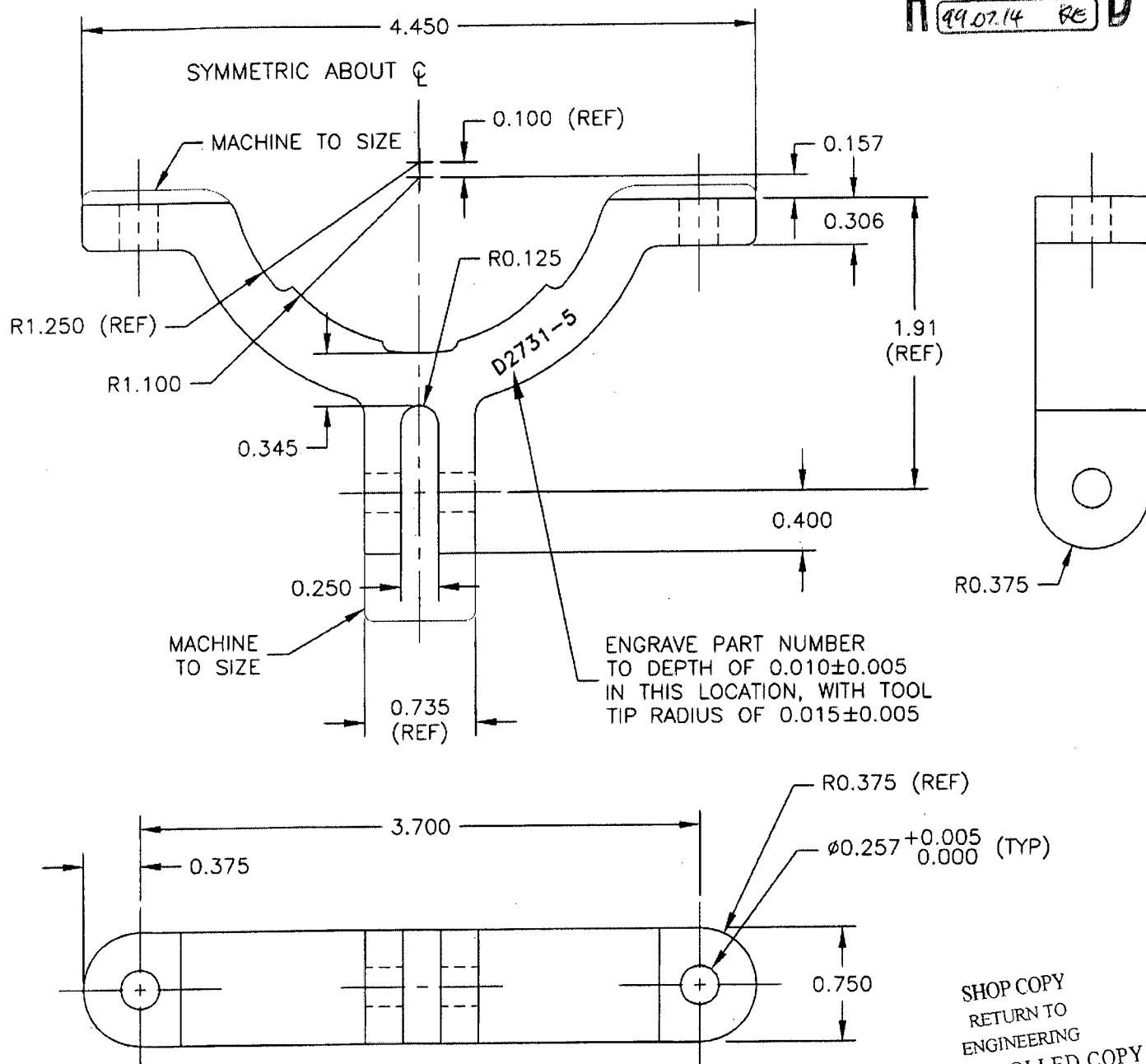
SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 32388





DESIGN <i>KE</i>	DRAWN BY <i>RF</i>	DART AEROSPACE USA, INC. FAIRCHILD INTERNATIONAL AIRPORT, WA
CHECKED <i>KE</i>	APPROVED <i>WS</i>	DRAWING NO. D2731
DATE 99.07.06		REV. B SHEET 3 OF 4 SCALE 1:1

**RELEASED**  
99.07.14 RE



MAKE FROM EXTRUSION D2423  
BREAK ALL EDGES 0.000–0.015  
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

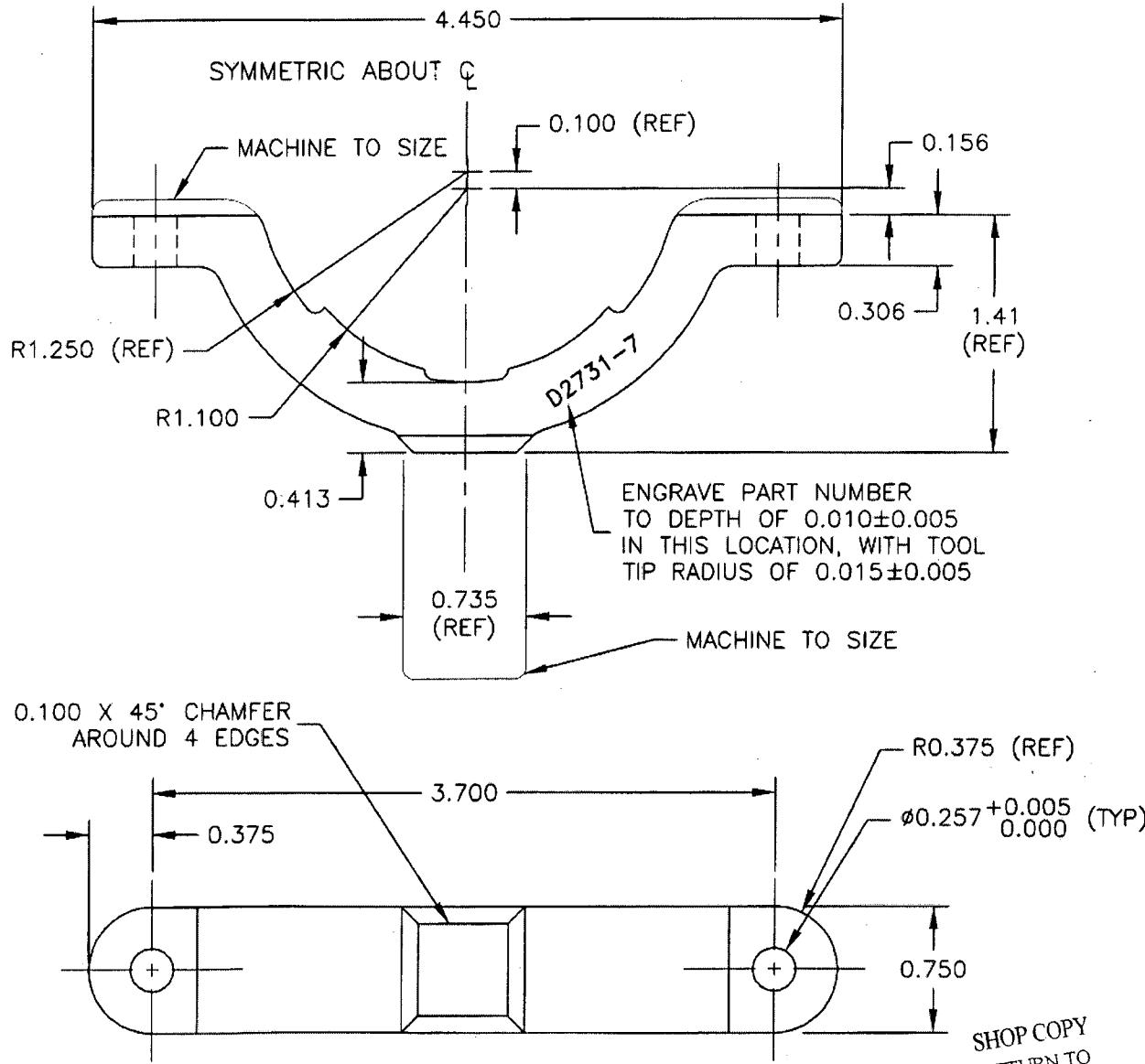
SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE

WORK ORDER  
NO. 32388



DESIGN <i>KE</i>	DRAWN BY <i>RF</i>	DART AEROSPACE USA, INC. FAIRCHILD INTERNATIONAL AIRPORT, WA
CHECKED <i>KE</i>	APPROVED <i>SC</i>	DRAWING NO. D2731
DATE 99.07.06		REV. B SHEET 4 OF 4 TITLE MOUNTING LUG SCALE 1:1

RELEASED  
99.07.14 KE



MAKE FROM EXTRUSION D2423  
BREAK ALL EDGES 0.000-0.015  
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. *32388*





20 Terry Fox Drive  
Vankleek Hill, Ontario K0B 1R0  
Tel: (613) 678-3957  
Fax: (613) 678-3956

Delivery Slip No.: 15909  
Date: Jun 01, 2007  
Page: 1

Sold to:	Ship to:
Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7	Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7
Order No.: 3812	Sold By: Walz, Christian D.
Shipped By: our truck	Ship Date:

Description	Unit	Ordered quantity	Shipped quantity	Backorder quantity
D2230-1 Mounting Lug B32163	Each	370		370
D2731-7 LUG B32387	Each	64	64	
D2731-7 LUG B32388	Each	64	64	

*JS 6/6/01*

Received by _____	Thank you for your order!
-------------------	---------------------------



## CERTIFICATE OF CONFORMITY

**SOLD TO:**

Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, Ont.  
K6A 1K7

**SHIPPED TO:**

same

<u>QUANTITY</u>	<u>PART NUMBER</u>	<u>PART NAME</u>	<u>P.O. NUMBER</u>
64	D2731-7	Lug B32387	3812
64	D2731-7	Lug B32388	3812

MATERIAL: supplied by DART D2423 B30062

A handwritten signature in black ink, appearing to read "Shigi (Regula) Walz". The signature is written in a cursive style with some loops and variations in line thickness.

We hereby certify that the above parts were made in conformance with applicable drawings.

*METEC Metal Technology Inc.*

A handwritten signature in black ink, appearing to read "Shigi (Regula) Walz". The signature is written in a cursive style with some loops and variations in line thickness.

Vankleek Hill, June 1, 2007